

Date: Monday, 2/5/2007 8:07:34 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FITTING		
Job Number	: 30604		Part Number	: D31981		
Estimate Number	: 10416		Drawing Number	: D3198 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	2/5/2007	S.O. No.	N/A	Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 2/9/2007		
Previous Run	: 30147		Qty:	20	Um:	Each
Written By						
Checked & Approved By						
Comment	: Est: A 03.11.11 New Issue KJ/RF Est Rev:B Now on Waterjet 07-01-09 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304S11GA	304/316 .125 Sheet
Comment: Qty.: 0.1103 sf(s)/Unit Total : 2.2050 sf(s) 304/316 .125 Sheet Batch: m102817 ml 07 03 06 (20)		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3198 Dwg Rev: A ml 07 03 06 (20) Prog Rev: A		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
ml 07 03 06 (20)		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Deburr if necessary 2-Form as per Dwg D3198		
SB 07/03/09 07/03/07 20 (20)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/03/13  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 8:07:34 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 30604

Part Number: D31981

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Mo7/03/09 (20)



Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING POWDER COATING



M 101601



(Q0X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 101601

07/03/09

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Mo7/03/09 (20)



Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Mo7/03/09 (20)



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Mo7/03/09 (20)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

Mo7/03/09 (20)

Job Completion



U 07.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

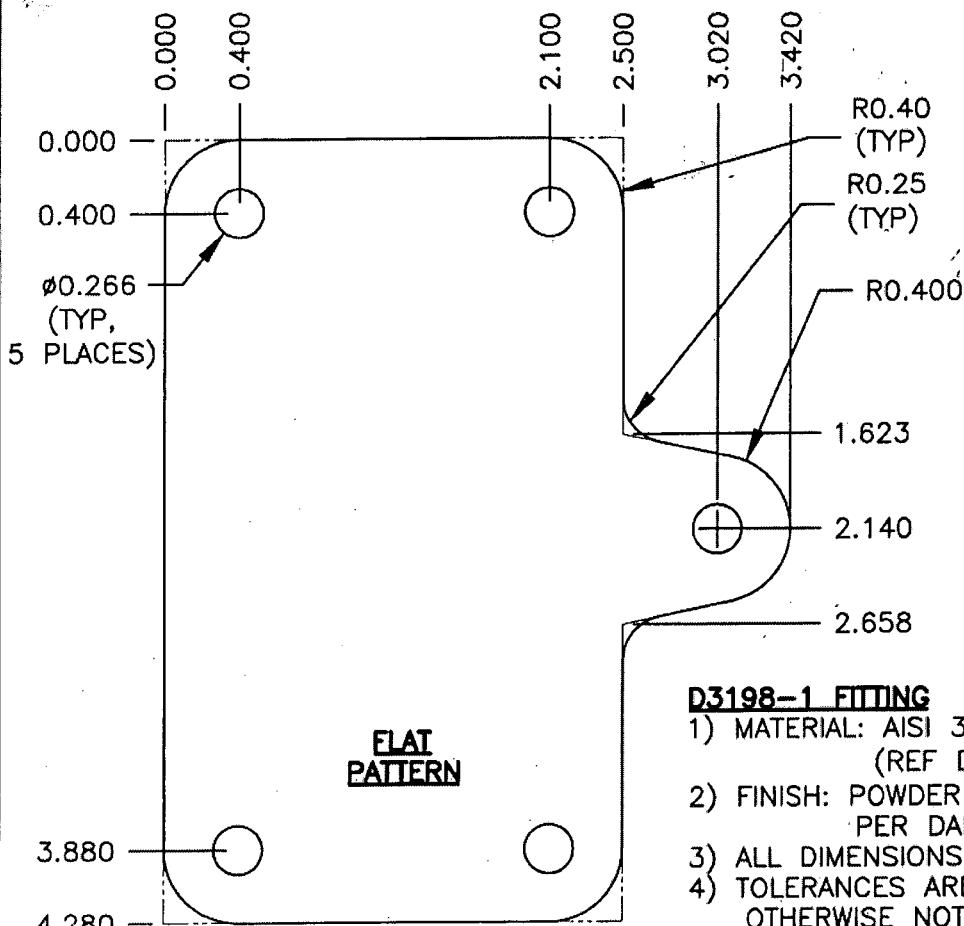
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



OFFICE COPY /  
C-100

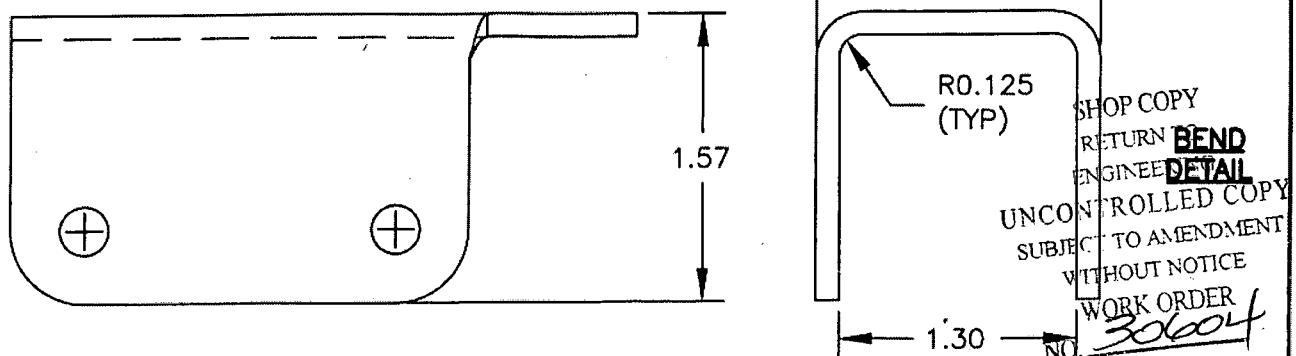
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3198
DATE		REV. A
03.09.26		SHEET 1 OF 1
		SCALE
		1:1
A	03.09.26	NEW ISSUE



RELEASED  
03.10.10

#### D3198-1 FITTING

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



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## DART AEROSPACE LTD

Work Order: 30604

Description: Fitting

Part Number: D3198-1

Inspection Dwg: 13198 . Rev: A

Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## **x First Article**

## x | Prototype

**Measured by:**

*m m*

**Audited by:**

14

### Prototype Approval:

Date:

Date: 07 03 06

Date:

07/03/06

## Business

Page 1

Date \_\_\_\_\_

## Change

## New Issue

**Revised**

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**Approved**